

Date: Monday, 6/2/2008 2:40:32 PM
 User: Chantal Lavoie

Process Sheet

072

Customer : CC-DAR01 Dart Aerospace Ltd. Drawing Name : BACK LEG ASSEMBLY
 Job Number : 39649
 Estimate Number : 13323
 P.O. Number :
 This Issue : 6/2/2008 S.O. No. :
 Prsht Rev. : NC
 First Issue : // Type : R & D SM/MED FAB
 Previous Run : 05011
 Written By :
 Checked & Approved By :
 Comment : Est Rev:A 08-05-19 new issue DD verified by:ec

Part Number : D3782045
 Drawing Number : PROTO
 Project Number :
 Drawing Revision : PROTO
 Material :
 Due Date : 6/9/2008

PROTOTYPE
 PLEASE RETURN ALL ISSUED
 DATA TO ENGINEERING
 0806.02

Qty: 2 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
 Pick Packing Kit

2.0 D37721 Back Leg



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)
 Back Leg
 batch: B38888

080603

3.0 D37871 Foot



BELL P/N205-070-786-001



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)
 Foot
 batch: B39634

080603

4.0 D37641 Back Leg Fitting



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)
 Back Leg Fitting
 batch: B39109

080602

5.0 D3773041 Headrest Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)
 Headrest Assembly
 batch: B05004

080603

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 6/2/2008 2:40:33 PM
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Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: BACK LEG ASSEMBLY

Job Number: 39649

Part Number: D3782045

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

AN515A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Bolt

batch: M108077

705

080603

7.0

AN45 15A

EYE BOLT



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

EYE BOLT

batch: M107938

705

080603

8.0

AN517A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Bolt

batch: M106815

705

080603

9.0

AN415A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s)

Bolt

batch: M107737

705

080603

10.0

NAS1149F0463P

Washer



AN960-416



Comment: Qty.: 4.0000 Each(s)/Unit Total: 8.0000 Each(s)

Washer

batch: M5519

705

080603

11.0

NAS1149F0563P

Washer



Comment: Qty.: 5.0000 Each(s)/Unit Total: 10.0000 Each(s)

Washer

batch: M108099

705

080603

12.0

MS21042L4

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s)

Nut

batch: M107478

705

080603

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: BACK LEG ASSEMBLY

Job Number: 39649

Part Number: D3782045

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

MS21042L5

Nut



Comment: Qty.: 3.0000 Each(s)/Unit Total: 6.0000 Each(s)

Nut

batch: M107464

Handwritten signature

080603

14.0

D37861

Sleeve



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Sleeve

batch: B39350

Handwritten signature

080603

15.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-assemble as per dwg D3782

Handwritten signature

080603

PTO →

16.0

QC5

INSPECT WORK TO CURRENT STEP



**ENGINEERING
APPROVAL**

ENG'G APPROVAL
08.06.03



Comment: INSPECT WORK TO CURRENT STEP

17.0

PACKAGING 1

PACKAGING RESOURCE #1



Handwritten signature
08.06.03



Comment: PACKAGING RESOURCE #1

Identify with Dart part # and batch # using a fine point permanent marker on inside of part and Stock

Location: _____

18.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08.06.03 Prototype

Job Completion



08.06.03

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
08.06.03	15	D3772-1 interior was machined $\phi 1.010" \times 3.25'$ DEEP ON BOTH ENDS TO ALLOW INSTALLATION OF D3773-041 and D3786-1	PA	01.06.03	ALL	PA 01.06.03	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

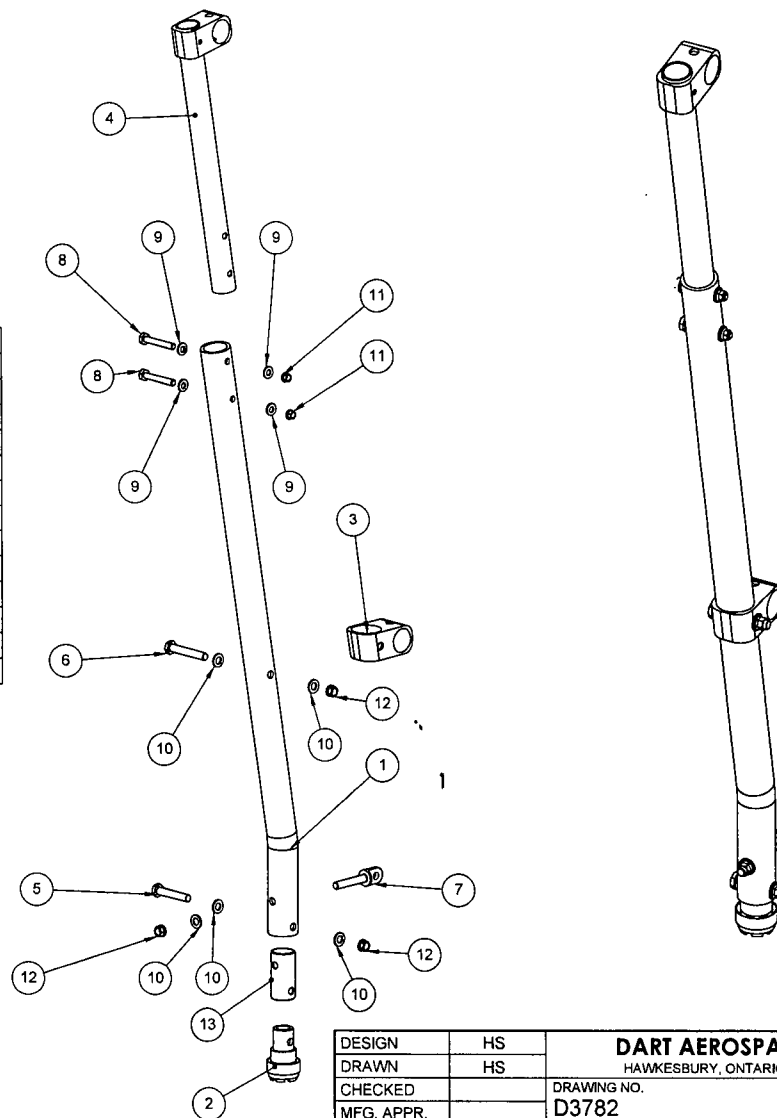
ITEM NO.	PART NUMBER	DESCRIPTION	QTY. (-045)
1	D3772-1	BACK LEG	1
2	D3787-1	FOOT	1
3	D3764-1	BACK LEG FITTING	1
4	D3773-041	HEAD REST ADAPTER ASSY	1
5	AN5-15A	BOLT	1
6	AN5-17A	BOLT	1
7	AN45-15A	EYE BOLT	1
8	AN4-15A	BOLT	2
9	NAS1149F0463P	WASHER	4
10	NAS1149F0563P	WASHER	5
11	MS21042L4	NUT	2
12	MS21042L5	NUT	3
13	D3786-1	SLEEVE	1

PROTOTYPE
PLEASE RETURN ALL ISSUED
DATA TO ENGINEERING
08-06-02 *RL*

D3782-045 BACK LEG ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A



DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	HS		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3782	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		LEG ASSEMBLY	1:1
DATE	08.05.15	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	